

Work Order ID 48568

June 26, 2009 4:16:51 PM



Page 1

Item ID: K642-512
Revision ID: N/A
Item Name: saddle kit 642-511

Accept



Setup Start



Stop



Start Date: 15/07/2009 Start Qty: 2.00
Required Date: 03/08/2009 Req'd Qty: 2.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
N/A	Rev N/A

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Create White labels per PPP K642-512 CHG003

for CL 8/06/30

110

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

100% 30 2

0.00

Picklist Print

June 26, 2009 4:16:50 PM

Page 1

Work Order ID: 48568

Parent Item: K642-512RevN/A

Parent Item Name: saddle kit 642-511

Comments:



Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
2 AN3C35A 		Purchased				120	Each 3	118.0000	6.0000 	M110155		
BOLT												
2 AN3C36A 		Purchased				120	Each 9	169.0000	18.0000 	M111917		
BOLT												
2 AN3C41A 		Purchased				120	Each 8	102.0000	16.0000 	M111925		
BOLT												
2 AN4C6A 		Purchased				120	Each 12	262.0000	24.0000 	M111724		
Bolt												
2 AN5C11A 		Purchased				120	Each 8	96.0000	16.0000 	M110925		
2 AN5C12A 		Purchased				120	Each 4	84.0000	8.0000 	M110847		
2 AN5C13A 		Purchased				120	Each 4	132.0000	8.0000 	M107800		
2 AN5C15A 		Purchased				120	Each 1	132.0000	2.0000 	M109148		
Bolt												9/6/30
2 AN5C32A 		Purchased				120	Each 2	122.0000	4.0000 	M110155		8/09/06/30 (12)

Picklist Print

June 26, 2009 4:16:50 PM

Page 2

Work Order ID: 48568

Parent Item: K642-512RevN/A

Parent Item Name: saddle kit 642-511



















Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN5C34A 		Purchased	No			120	Each 2	116.0000	4.0000	 M110342	SS 09/06/30 (x2)	
AN5C35A 		Purchased	No			120	Each 2 1	131.0000	2.0000	 M107551	SS 09/06/29 (x2)	
AN960C10L 		Purchased	No			120	Each 24	5,096.0000	48.0000	 M112116	SS 09/06/29 (x2)	
washer AN960C416L 		Purchased	No			120	Each 24	568.9996	48.0000	 M111808	SS 09/06/29 (x2)	
WASHER AN960C516L 		Purchased	No			120	Each 8	381.0000	16.0000	 M111650	SS 09/06/29 (x2)	
WASHER D206-648-013RevB 		Manufactured	No			120	Each 1	4.0000	2.0000	 SS 09/06/29 B48226 (x2)		
GHW Modification D2652RevA 		Manufactured	No			120	Each 16	351.0000	32.0000	 SS B48187 SS 09/06/29 (x2)		
Bushing D2712RevB 		Manufactured	No			120	Each 10	481.0000	20.0000	 B47603	SS 09/06/29 (x2)	
Set Screw D2932-2RevC 		Manufactured	No			120	Each 1	12.0000	2.0000	 B47908 x1 B45263 x2	SS 09/06/29 (x2)	
Saddle RH Out, 206												

June 26, 2009 4:16:50 PM

Shop Packet Print

Page 2

Picklist Print

June 26, 2009 4:16:50 PM

Work Order ID: 48568

Parent Item: K642-512RevN/A

Parent Item Name: saddle kit 642-511

Comments:



Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
1 D2933-2RevC 		Manufactured	No			120	Each 1	8.0000	2.0000 	B47968	8/09/06/29 (x2)	
Saddle RH In, 206												
2 D2934RevB 		Manufactured	No			120	Each 2	52.0000	4.0000 	B47947	8/09/06/29 (x2)	
Saddle Spacer												
3 D2935RevB 		Manufactured	No			120	Each 2	55.0000	4.0000 	B47948	8/09/06/29 (x2)	
Saddle Spacer												
4 D2938-2RevC 		Manufactured	No			120	Each 1	11.0000	2.0000 	B48192	8/09/06/29 (x2)	
Saddle RH Out, 206												
5 D2939-2RevC 		Manufactured	No			120	Each 1	11.0000	2.0000 	B47116	8/09/06/29 (x2)	
Saddle RH In, 206												
6 D3396-3RevB 		Manufactured	No			120	Each 2	81.0000	4.0000 	B45667	8/09/06/29 (x2)	
Spacer												
7 D3407-043RevE 		Manufactured	No			120	Each 1	31.0000	2.0000 	B47857	8/09/06/29 (x2)	
Tow Ring												
8 D3456-1RevA 		Manufactured	No			120	Each 1	70.0000	2.0000 	8/09/06/29 B46752		
Washer												
9 D3457-1RevA 		Manufactured	No			120	Each 2	109.0000	4.0000 	B45913	8/09/06/29 (x2)	
Washer												

June 26, 2009 4:16:50 PM

Shop Packet Print

7

Picklist Print

June 26, 2009 4:16:50 PM

Page 4

Work Order ID: 48568

Parent Item: K642-512RevN/A

Parent Item Name: saddle kit 642-511














Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
7 D3672-1RevB 		Manufactured	No			120	Each 24	784.0000	48.0000	 B47628	09/06/29	(x2)
7 Phenolic Washer D3672-3RevB 		Manufactured	No			120	Each 24	582.0000	48.0000	B48258 x 39 B47023 x 9	09/06/29	(x2)
2 Phenolic Washer D3672-5RevB 		Manufactured	No			120	Each 16	206.0000	32.0000	 B44679	09/06/29	(x2)
7 Phenolic Washer D3672-7RevB 		Manufactured	No			120	Each 8	350.0000	16.0000	 B35522	09/06/29	(x2)
2 Phenolic Washer MS21043-3 		Purchased	No			120	Each 20	352.0000	40.0000	 M111819	09/06/29	(x2)
2 Nut MS21043-4 		Purchased	No			120	Each 13	276.0000	26.0000	 M111819	09/06/29	(x2)
2 Nut MS21043-5 		Purchased	No			120	Each 4	256.0000	8.0000	 M111119	09/06/29	(x2)

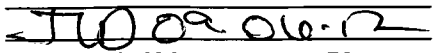
June 26, 2009 4:16:51 PM

Shop Packet Print

Page 4

Date: Friday, 12/06/2009 10:00:30 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE KIT FOR D206-642-512	
Job Number :	48568			
Estimate Number :	12894			
P.O. Number :		Part Number :	K642 512	
This Issue :	12/06/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	N/A	
First Issue :	//	Project Number :	N/A	
Previous Run :	48172	Drawing Revision :	N/A	
Written By :		Material :		
Checked & Approved By :			Due Date :	25/06/2009
Comment :	: Est Rev:A 05.06.07 new issue EC		Qty:	2 Um: Each
	: Est. Rev.B 05.02.08, Per ECN1080P			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



HJ for CL 09/06/30



Comment: Create White labels per PPP K642-512 CHG003

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	<input checked="" type="checkbox"/> D206648013	<input checked="" type="checkbox"/> GHW Modification
-----	--	--



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D206-648-013	GHW Kit	

4.0	<input checked="" type="checkbox"/> D2652	<input checked="" type="checkbox"/> Bushing
-----	---	---



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
16	D2652	Bushing	

5.0	<input checked="" type="checkbox"/> D2712	<input checked="" type="checkbox"/> Set Screw
-----	---	---



Comment: Qty.: 10.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
10	D2712	Set Screw	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/06/2009 10:00:30 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-512

Job Number: 48568

Part Number: K642 512

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	D29322	Saddle RH Out, 206
-----	--------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2932-2	Saddle	

7.0	D29332	Saddle RH In, 206
-----	--------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2933-2	Saddle	

8.0	D2934	Saddle Spacer
-----	-------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2934	Saddle Spacer	

9.0	D2935	Saddle Spacer
-----	-------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2935	Saddle Spacer	

10.0	D29382	Saddle RH Out, 206
------	--------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2938-2	Saddle	

11.0	D29392	Saddle RH In, 206
------	--------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2939-2	Saddle	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/06/2009 10:00:30 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-512

Job Number: 48568

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

✓ D33963

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3396-3	Spacer	

13.0

✓ D3407043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3407-043	Tow Ring	

14.0

✓ D34561

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3456-1	Washer	

15.0

✓ D34571

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3457-1	Washer	

16.0

✓ AN3C35A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	AN3C35A	Bolt	

17.0

✓ AN3C36A

BOLT



Comment: Qty.: 9.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
9	AN3C36A	Bolt	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/06/2009 10:00:30 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-512

Job Number: 48568

Part Number: K642 512

Job Number:



Seq. #: Machine Or Operation:

Description :

18.0

✓ AN3C41A ✓

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN3C41A Bolt

19.0

✓ AN4C6A ✓

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN4C6A Bolt

20.0

✓ AN5C11A ✓



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN5C11A Bolt

21.0

✓ AN5C12A ✓



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C12A Bolt

22.0

✓ AN5C13A ✓



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C13A Bolt

23.0

✓ AN5C15A ✓



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN5C15A Bolt

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/06/2009 10:00:30 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-512

Job Number: 48568

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN5C32A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C32A

Bolt

25.0

AN5C34A



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C34A

Bolt

26.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C35A

Bolt

27.0

AN960C10L



washer

Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C10L

Washer

28.0

AN960C416L



WASHER

Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C416L

Washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/06/2009 10:00:30 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-512

Job Number: 48568

Part Number: K642 512

Job Number:



Seq. #: Machine Or Operation: Description :

29.0 ✓ AN960C516L ✓ WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	AN960C516L	Washer	

30.0 ✓ MS210433 ✓ Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	MS21043-3	Nut	

31.0 ✓ MS210434 ✓ Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 26.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
13	MS21043-4	Nut	

32.0 ✓ MS210435 ✓ Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	MS21043-5	Nut	

33.0 ✓ D36721 ✓ Phenolic Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

PHENOLIC WASHER

34.0 ✓ D36723 ✓ Phenolic Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

PHENOLIC WASHER

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/06/2009 10:00:31 AM
User: Julie Dawes

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-512

Job Number: 48568

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0



D36725



Phenolic Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)
PHENOLIC WASHER

36.0



D36727



Phenolic Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)
PHENOLIC WASHER

37.0



QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

38.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP K642-512 CHG003
Location: _____

39.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries